



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4840-041
Job Sheet 186580



008158

Part No: D4840-041

Job Qty: 3 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Ship Via:

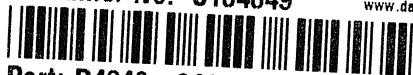
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	3 pcs		1/4/19	0.00	0.00	Packaging 1 - 1		FEB 15 2019
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		
							Packaging 1 - 32		



Container No: S154349



Part: D4840-041

Job No: 186580

Serial No/Batch: S154349

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/15/19

				Packaging 1 - 33 ^{Plex} 1/29/19 3:36 PM Dart.Hadley.Shannon	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120	Small Fab - 2 - B4B	3 pcs	1/4/19	0.00 3.77	Small Fab - 1 - B4B
					Small Fab - 2 - B4B
					Small Fab - 3 - B4B
					Small Fab - 4 - B4B
					Small Fab - 5 - B4B
					Small Fab - 6 - B4B
					Small Fab - 7 - B4B
130	QC 5	3 pcs	1/4/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 38
					QC 5 - 42
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
140	Packaging 3-1 - Stock - B4B	3 pcs	1/4/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B

DAS

36

9-89

DAS

FEB 21 2019

9-89

ccK0415

FEB 21 2019

				Packaging 3 - 32 - B4B	Plex 1/29/19 3:36 PM Dart.Hadley.Shannon
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	145
150 QC 21 - SA	3 pcs	1/4/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	205

FEB 21 2019

Part Op **110** - Pick Kit
 Descriptions: **120** - Small Fab - Assemble as per dwg and apply loctite 598 on all faying surfaces. A/R LOCTITE 598: _____
130 - QC5- Inspect part completeness to step on W/O
140 - Identify as per dwg & Stock Location: _____
150 - Identify as per dwg & Stock Location: _____

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D4823-1	✓ Upper Cutter Deflector	3 Ea (1 ea)	110-Packaging 1 - Pick Kit	5147722	
D4824-1	Upper Cutter Mount	3 Ea (1 ea)	110-Packaging 1 - Pick Kit	5015992	
D4838-1	Upper Cutter Body, LH	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	5025186x1 5025170x2	
D4838-2	Upper Cutter Body, RH	3 pcs (1 ea)	110-Packaging 1 - Pick Kit	5025273	
D4839-1	Blade	6 pcs (2 ea)	110-Packaging 1 - Pick Kit	5133379	
MS21042L08	Nut	42 Ea (14 ea)	110-Packaging 1 - Pick Kit	5080644	
MS27039-08-19	Screw	42 Ea (14 ea)	110-Packaging 1 - Pick Kit	5104359	
NAS1149FN832P	Washer	84 Ea (28 ea)	110-Packaging 1 - Pick Kit	5134368	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D4823-1	3	10	0
	D4824-1	3	3	0
	D4838-1	3	11	0
	D4838-2	3	11	0
	D4839-1	6	16	0
	MS21042L08	42	1,225	0
	MS27039-08-19	42	836	0
	NAS1149FN832P	84	3,162	0

Part Specifications
Specifications could not be found.

Plex 1/29/19 3:36 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4840-041
Job Sheet 186580



Part No: D4840-041

Job Qty: 3 ea

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/17/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 13.04.29 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	3 pcs	1/4/19	1/4/19	0.00	0.00	Packaging1-5		
120	Small Fab	3 pcs	1/4/19	1/4/19	0.00	3.77	Small Fab-7		
130	QC	3 pcs	1/4/19	1/4/19	0.00	0.00	QC5		
140	Packaging	3 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3-2		
150	QC21-SA	3 Ea	1/4/19	1/4/19	0.00	0.00	QC21		

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces. A/R LOCTITE 598: _____
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4823-1	Upper Cutter Deflector	3 Ea (1 ea)	90-Start up Operation	
D4824-1	Upper Cutter Mount	3 Ea (1 ea)	90-Start up Operation	
D4838-1	Upper Cutter Body, LH	3 pcs (1 ea)	90-Start up Operation	
D4838-2	Upper Cutter Body, RH	3 pcs (1 ea)	90-Start up Operation	
D4839-1	Blade	6 pcs (2 ea)	90-Start up Operation	
MS21042L08	Nut	42 Ea (14 ea)	90-Start up Operation	
MS27039-08-19	Screw	42 Ea (14 ea)	90-Start up Operation	
NAS1149FN832P	Washer	84 Ea (28 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4823-1	3	0	0
	D4824-1	3	3	0
	D4838-1	3	11	0
	D4838-2	3	11	0
	D4839-1	6	16	0
	MS21042L08	42	1,464	0
	MS27039-08-19	42	992	0
	NAS1149FN832P	84	2,014	0

Part Specifications
Specifications could not be found.

Plex 1/9/19 7:49 AM dart.quirion.sonia